

Work Order ID 146316-2

146316

Page 1

Tuesday, May 17, 2016 1:58:07 PM

Item ID: PB67-43001-01

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MF

Date: 16-5-17

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-01

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

2.64

1- Assemble as per dwg and notes on dwg B67-43001 and use 242 threadlock Blue

A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK Blue batch:

A/R touch up paint with sandflex green batch: 126701

134416

JUN 21 2016

DAS	DAS
24	24
9-89	9-89

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.04

Quality Control

16-06-24

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Item ID: PB67-43001-01

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: _____	0.00							
120									
Packaging	Memo	0.02							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.20							
Quality Control									

DAS
27
9-89
JUN 27 2016

16/6/27

SH 6/27/16

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Work Order ID: 146316

146316

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP
RevC 10.09.24 per RevC EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107		Purchased	No			100	Each	246.0000	8	16			
240-107									**				
SPRING SLOTTED PIN													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST579		246							
				m132006		46							
				m134651		200							
30345T22		Purchased	No			100	Each	10.0000	2	4			
30345T22									**				
8" LANYARD													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST570		10							
				m132610		10							
30345T24		Purchased	No			100	Each	16.0000	2	4			
30345T24									**				
LANYARDS													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST581		16							
				m134210		3							
				m134499		8							
				m134656		5							

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Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-10A

Purchased

No

100

Each

193.0000

2

4

AN4-10A

Bolt

**

Location

Loc Qty

Loc Code

CA

13

M129682

13

over003

125

M134762

125

ST345

55

131677

5

M133234

50

AN4-13A

Purchased

No

100

Each

325.0000

2

4

AN4-13A

Bolt

**

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

60

m134167

36

m134634

24

O003

200

m134754

200

ST344

45

m134634

45

DATE
6
9-88

DATE
6
9-88

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Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-15A	Purchased	No	100	Each	442.0000	4	8	
AN4-15A								
Bolt								

Location	Loc Qty	Loc Code
GA	26	
120449	26	
OVER002	150	
m134762	150	
over003	200	
m134676	200	
ST343	66	
m134606	66	

AN6-11A	Purchased	No	100	Each	31.0000	2	4	
AN6-11A								
BOLT								

Location	Loc Qty	Loc Code
ST335	31	
M132576	31	

AN6-20A	Purchased	No	100	Each	33.0000	2	4	
AN6-20A								
BOLT								

Location	Loc Qty	Loc Code
over005	30	
M133932	30	
ST334	3	
M128936	3	

To Long

DAS 24 9-89

AN6-16A

DAS 22 9-89 16.06.13

M132576 → 4

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Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

AN8-13A

Purchased

No

100

Each

23.0000

2

4

AN8-13A

Bolt

**

DAS
24
9-89

Location

Loc Qty

Loc Code

ST332

23

M132576

7

M134497

16

BSP43

Purchased

No

100

Each

81.0000

4

8

RSP43

RIVET

**

DAS
24
9-89

Location

Loc Qty

Loc Code

ST558

81

M132703

81

CR3213-4-05

Purchased

No

100

Each

120.0000

2

4

CR3213-4-05

RIVET

**

DAS
24
9-89

Location

Loc Qty

Loc Code

CCK003

120

m134497

120

D3445-041

Manufactured

No

100

Each

12.0000

1

2

D3445-041

Belt Assembly

**

JUN 06 2016

Location

Loc Qty

Loc Code

Mezz2

12

108356

1

133676

1

142650

10

DAS
24
9-89

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Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

D3447-3

Manufactured No

100

Each

17.0000

2

4 JUN 15 2016

DAS

D3447-3

Square Spacer

**

24
9-89

Location

Loc Qty

Loc Code

Mezz2

17

133683

1

142211

16

4.3

D3447-7

Manufactured No

100

Each

16.0000

2

4 JUN 15 2016

DAS

D3447-7

Clevis

**

24
9-89

Location

Loc Qty

Loc Code

Mezz2

16

142212

16

4

D3447-9

Manufactured No

100

Each

11.0000

2

D3447-9

Swing Arm

**

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

11

142213

11

4

D3451-041

Manufactured No

100

Each

2.0000

1

D3451-041

Handle And Lock-Down Assembly

**

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

2

142168

2

2

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PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

D3451-047

Manufactured No

100

Each

3.0000

1

2 JUN 15 2016

DAS
24
9-89

D3451-047

Handle And Lock-Down Assembly

**

Location

Loc Qty

Loc Code

Mezz2

3

142171

3

100

Each

17.0000

2

4

**

DAS
6
9-89

D3922-1

Manufactured No

D3922-1

Clip

Location

Loc Qty

Loc Code

ST059

17

111733

17

100

Each

16.0000

2

4

**

DAS
6
9-89

MS17984-C408

Purchased No

MS17984-C408

PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

16

m128051

4

m132576

12

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Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

MS17984-C418

Purchased

No

100

Each

31.0000

2

4

MS17984-C418

QUICK RELEASE PIN

**

134676

Location

Loc Qty

Loc Code

CCK005

12

m134676

12

FG

1

123482

1

ST

5

145507

5

ST315

13

m134478

5

m134502

8

DAG
6
2-89

MS21042L3

Purchased

No

100

Each

1,800.000

2

4

MS21042L3

Nut

**

DAG
6
9-85

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

254

m133790

3

m134360

251

ST303

1446

m134039

12

m134360

234

m134634

600

m134754

600

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Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

100

Each

2,169.000

8

16

DAS

MS21042I 4

Locknut

**

6

9-80

Location

Loc Qty

Loc Code

GA

187

m133769

187

OVER007

1500

m134676

500

m134762

1000

ST303

385

m134606

385

ST305

97

m130922

97

DAS

6

9-80

MS21042L6

Purchased

No

100

Each

263.0000

4

8

MS21042I 6

Nut

**

Location

Loc Qty

Loc Code

ST303

263

m133938

6

m134055

7

m134509

100

m134567

50

m134676

100

MS27039-1-04

Purchased

No

100

Each

84.0000

2

4

MS27039-1-04

Screw

**

DAS

6

9-80

Location

Loc Qty

Loc Code

ST281

84

m134634

84

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Work Order ID: 146316

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Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-21

Purchased

No

100

Each

303.0000

2

4

MS27039-1-21

Screw

**

DAS

6

9-88

Location

Loc Qty

Loc Code

over006

100

m127904

100

ST280

203

m127904

203

MS51859-6

Purchased

No

100

Each

86.0000

4

8

MS51859-6

WASHER

**

DAS

6

9-88

Location

Loc Qty

Loc Code

st268

86

132703

6

m134502

80

MS51859-7

Purchased

No

Each

33.0000

8

MS51859-7

Washer

**

DAS

6

9-88

Location

Loc Qty

Loc Code

st268

33

M132576

33

MS51859-8

Purchased

No

100

Each

312.0000

8

16

MS51859-8

Washer

**

DAS

6

9-88 JUN 06 2016

Location

Loc Qty

Loc Code

st268

312

m132576

12

m134606

300

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Work Order ID: 146316

146316

Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149DN632J

Purchased

No

100

Each

722.0000

6

12

NAS1149DN632J

Washer

**

DAG

6

9-80

Location

Loc Qty

Loc Code

ST264

722

m133860

22

m134370

700

12

NAS1149F0316P

Purchased

No

100

Each

167.0000

4

8

NAS1149F0316P

WASHER

**

DAG

6

9-80

Location

Loc Qty

Loc Code

ST262

167

M132579

167

8

NAS1149F0432P

Purchased

No

100

Each

1,310.000

16

32

NAS1149F0432P

WASHER

**

DAG

6

9-80

Location

Loc Qty

Loc Code

ST260a

1000

M134502

1000

32

ST262

189

M133990

189

st268

121

M132677

121

NAS1149F0632P

Purchased

No

100

Each

218.0000

8

16

NAS1149F0632P

WASHER

**

DAG

6

9-80

Location

Loc Qty

Loc Code

ST262

218

18057

18

m134497

200

JUN 06 2016

16

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Work Order ID: 146316

146316

Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0832P

Purchased

No

100

Each

137.0000

2

4

NAS1149F0832P

WASHER

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST262

137

18057

137

NAS43DD3-68

NAS43DD3-68FC

Purchased

No

100

Each

0.0000

2

4

NAS43DD3-68

Spacer

PB67-43001-07

Manufactured

No

100

Each

0.0000

1

2

**B/46318

JUN 15 2016 JUN 06 2016

DAS

24

9-89

PR67-43001-07

Fwd Blade Fold Assembly Weldment

PB67-43001-11

Manufactured

No

100

Each

0.0000

1

2

**B/42620

JUN 15 2016

DAS

24

9-89

PR67-43001-11

Fwd Adjustable Blade Support Assembly

PB67-43001-15

Manufactured

No

100

Each

0.0000

1

2

**B/42595

JUN 15 2016

DAS

24

9-89

PR67-43001-15

Fwd Adjustable Blade Support Assembly

PB67-43001-21

Manufactured

No

100

Each

0.0000

1

2

**B/42800

JUN 15 2016

DAS

24

9-89

PR67-43001-21

Upper Blade Support And Cover Assembly

PB67-43001-23

Manufactured

No

100

Each

0.0000

1

2

**B/42801

JUN 15 2016

DAS

24

9-89

PR67-43001-23

Lower Blade Support And Cover Assembly

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Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 5/18/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

DAS

PB67-43001-261

Manufactured No

100 Each

15.0000 2 4

24

9-89

PR67-43001-261

Lever Arm

**

JUN 15 2016

Location

Loc Qty

Loc Code

Mezz2

15

139215

15

PB67-43001-265

Manufactured No

100 Each

47.0000 4 8

DAS

24

9-89

PR67-43001-265

Deltin Bushing

**

JUN 15 2016

Location

Loc Qty

Loc Code

Mezz2

47

133685

7

139214

40

PB67-43001-299

Manufactured No

100 Each

25.0000 2 4

DAS

24

9-89

PR67-43001-299

Bushing

**

JUN 15 2016

Location

Loc Qty

Loc Code

Mezz2

25

113390

1

139216

24

PB67-43001-45

Manufactured No

100 Each

1.0000 1 2

DAS

24

9-89

PR67-43001-45

Longitudinal Support

**

B/42414 → 1

JUN 15 2016

Location

Loc Qty

Loc Code

Mezz2

1

142209

1

PB67-43001-51

Manufactured No

100 Each

0.0000 1 2

DAS

24

9-89

PR67-43001-51

Long T-Handle Assembly

**

B/42412

JUN 15 2016

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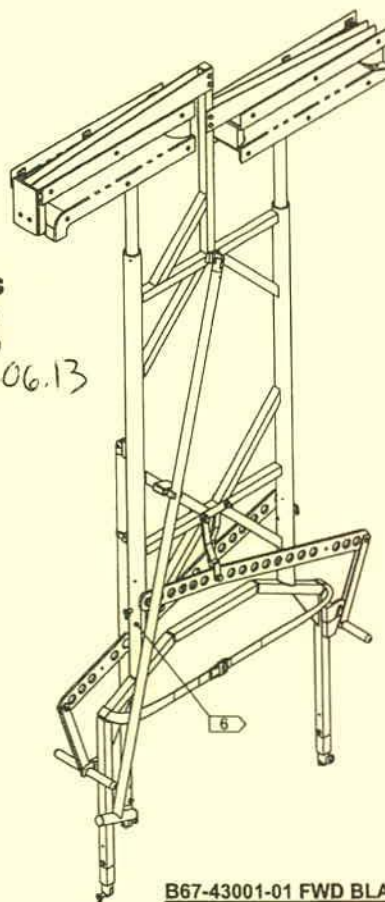
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ITEM	QTY. -01	P/N	DESCRIPTION
	X	B67-43001-01	FWD BLADE FOLD ASSY
1	1	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-45	LONGITUDINAL SUPPORT
7	1	B67-43001-51	LONG T-HANDLE ASSY
8	2	B67-43001-261	LEVER ARM
9	4	B67-43001-265	DELFIN BUSHING
10	2	B67-43001-299	BUSHING
11	1	D3445-041	BELT ASSEMBLY
12	2	D3447-3	SQUARE SPACER
13	2	D3447-7	CLEVIS
14	2	D3447-9	SWING ARM
15	1	D3451-041	HANDLE & LOCK-DOWN ASSY
16	1	D3451-047	HANDLE & LOCK-DOWN ASSY
17	2	D3922-1	CLIP
18	2	30345T22	LANYARD
19	2	30345T24	LANYARD
20	2	AN4-10A	BOLT
21	2	AN4-13A	BOLT
22	4	AN4-15A	BOLT
23	2	AN6-11A	BOLT
24	2	AN6-20A	BOLT AN6-16A
25	2	AN8-13A	BOLT
26	4	BSP43	RIVET
27	2	CR3213-4-05	RIVET
28	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
29	2	MS17984-C408	QUICK RELEASE PIN
30	2	MS17984-C418	QUICK RELEASE PIN
31	2	MS21042L3	NUT
32	8	MS21042L4	NUT
33	4	MS21042L6	NUT
34	2	MS27039-1-04	SCREW
35	2	MS27039-1-21	SCREW
36	4	MS51859-6	NYLON WASHER
37	4	MS51859-7	NYLON WASHER
38	8	MS51859-8	NYLON WASHER
39	2	NAS43DD3-68	SPACER
40	6	NAS1149DN632J	WASHER
41	4	NAS1149F0316P	WASHER
42	16	NAS1149F0432P	WASHER
43	8	NAS1149F0632P	WASHER
44	2	NAS1149F0832P	WASHER
45	A/R	242XX	LOCTITE 242 THREADLOCKER, BLUE

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 49.07 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL Ø0.250 DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THROUGH THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL (2 PL PER BUSHING).
- 10) PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MS51859 EQUIVALENT
- 11) TRIM HEAD OF MS17984-C408 QUICK PIN FLUSH TO BODY AS SHOW. TOUCH UP WITH BLACK PAINT PRIOR TO FASTENING TO FRAME.



B67-43001-01 FWD BLADE FOLD ASSY

RELEASED
2010-09-21
AMP

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 2 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011	VS	10.06.11
REV.	DESCRIPTION		BY	DATE
DESIGN	RW		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		DRAWING NO. B67-43001-01 REV. C	
CHECKED	[Signature]		SHEET 1 OF 2	
MFG. APPR.	[Signature]		SCALE	
APPROVED	[Signature]		TITLE FWD BLADE FOLD ASSY NTS	
DE APPR.	[Signature]		DATE 10.06.11	
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